

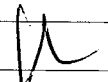
Work Order ID 132406

132406

Page 1

May-07-15 2:40:24 PM

Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center Fwd
 Start Date: 5/07/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100		0.00							
100									
Waterjet	Memo	0.00							

FLOW CNC Waterjet

304.040~

1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
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Root Cause		FAULT CATEGORY																							
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 132406

132406

Page 3

May-07-15 2:40:24 PM

Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center Fwd
 Start Date: 5/07/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						13			EN 15-05-15
HandFinish	Memo	0.00							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>132115</u>								
160	QC3- Inspect Part Finish	0.00							
160						(13)		DAS 38 9-00	MAY 19 2015
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170						X13	0	211310515	
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

May-07-15 2:40:24 PM

Page 1

Work Order ID: 132406

132406

Parent Item: D4956-23

D4956-23

Parent Item Name: Wearplate Center Fwd

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

sf

227.6623

15.78947

M304S20GA

(16)

Jm 15-5-14

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

119.9

m131700

119.9

131700.

MAT020

107.7623

m130345

1.5139

m131060

106.2484

DQA: _____ Date: _____



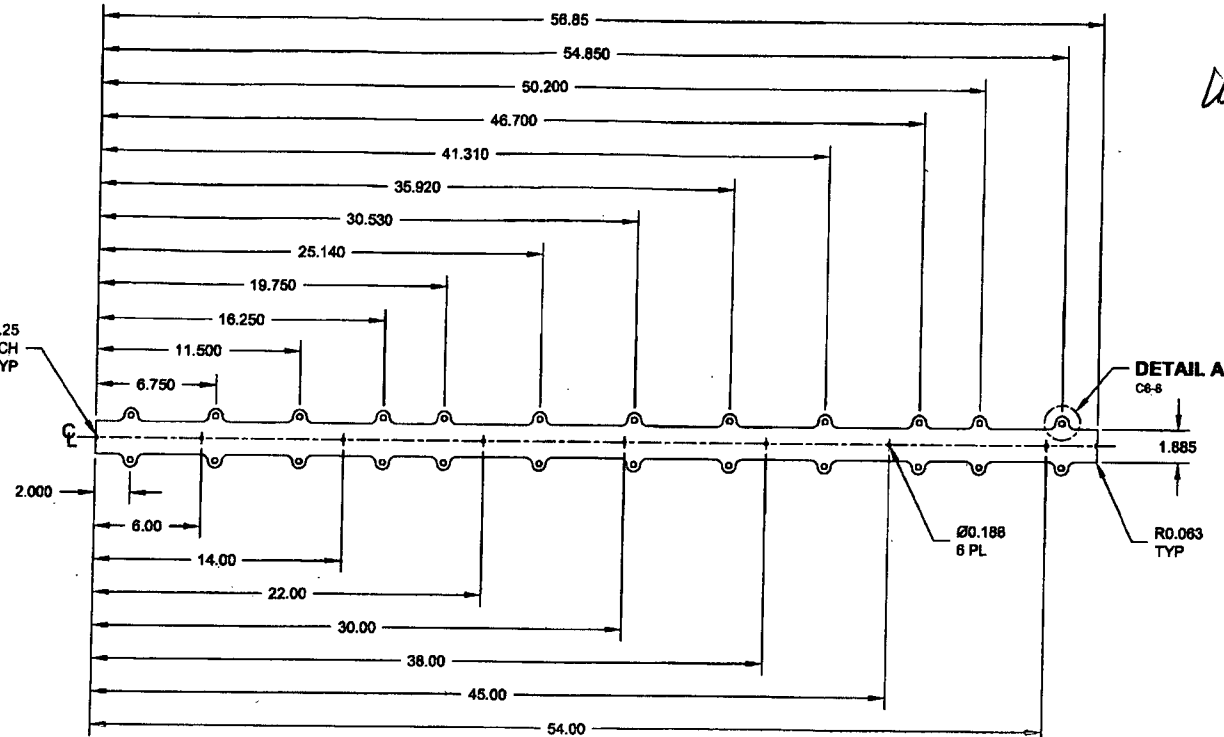
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

R0.25
TOOLING NOTCH
TYP



D4956-23F FLAT PATTERN



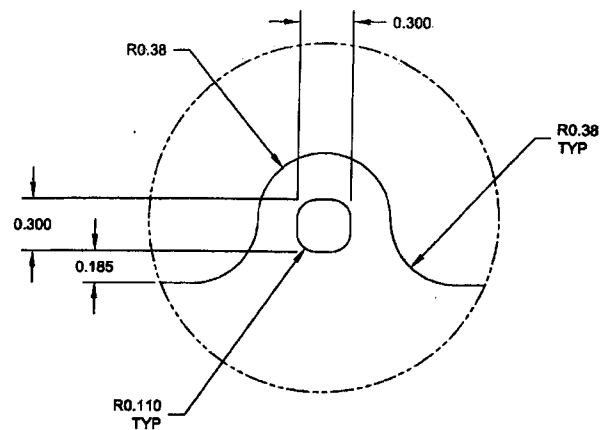
D4956-23 WEARSHOE
(MAKE FROM D4956-23F)

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

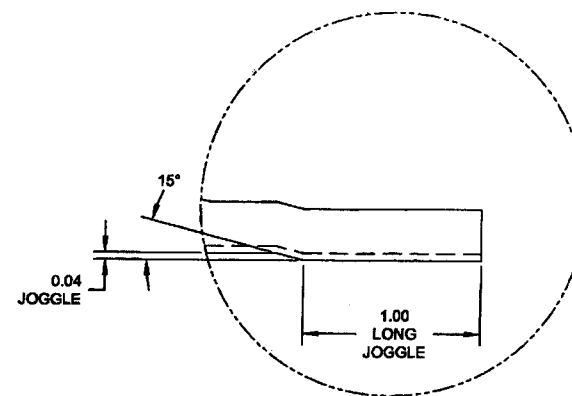
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4956	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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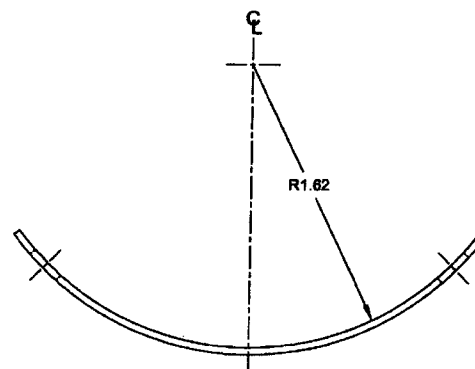
DETAIL A

C8-1	C4-1
C8-2	
C8-3	C1-3
C2-4	
C8-5	C2-5
C8-6	C2-6
C4-7	C3-7



DETAIL B

B6-1	B2-1
B3-2	
B6-3	B1-3
B2-4	
B4-7	B1-7



SECTION C-C

B7-1	B3-1
B5-2	
B7-3	B3-3
B8-4	
B7-5	B3-5
B7-6	B3-6
B7-7	B3-7

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